



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Hoop- ATTACHMENT No. of pieces: 5

Manufacturer: Aero Design

Part No.: 90622-01 Serial / Batch No.: 14009

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2014-36

Remaining Tasks to be Performed: mill for legs

Signature: [Signature]

Date: 11 APRIL 31, 2014 Lic. No. / ACA A006

In Process



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AMF 73-04

Nomenclature: Half hoop No. of pieces: 5

Manufacturer: AERO Design

Part No.: 90621-01 Serial / Batch No.: 14009

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2014-36

Remaining Tasks to be Performed: weld handle bushings, weld
to 1" hoop

Signature: _____

Date: MAR 14 3, 2014 Lic. No. / ACA AD06

In Process



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AMF 73-04

Nomenclature: 1" Half hoop No. of pieces: 5

Manufacturer: Aero Design

Part No.: 90621-01 Serial / Batch No.: 14014

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2014-36

Remaining Tasks to be Performed: mill for slots and lips

Signature: [Signature]

Date: MARCH 31, 2014 Lic. No. / ACA 1006

In Process



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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: LH R44 mount hoop No. of pieces: 5

Manufacturer: Aero Design

Part No.: 90622-01 Serial / Batch No.: 90622-01-01

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2014-36

Remaining Tasks to be Performed: Remove writing, dig to

bucket

Signature: [Signature]

Date: Apr 24, 2014 Lic. No. / ACA A001

In Process

Date Opened: 25 March 2014

Job #: 906

Type / Project: Robinson R44 Standard Cargo Basket Mounting Hoops

Batch Quantity: 5

Approval: SH10-48

Drawing List: DCL906-12, Rev. 0

Drawing	Description	Task Sheet		Material List	
		Provided	Complete	Provided	Complete
90621, Rev. 0	Aft Attachment Hoop	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
- 84262, Rev. 1	Basket Handle Provisions				
90622, Rev. 0	Forward Attachment Hoop	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:

Y

Document Control List revision level matches (or exceeds) STC:

Y

Drawings revision levels match Document Control List:

Y

Purchase order or Work order source is recorded for each part/ass'y:

Y

Tests and inspections specifically called out on drawings are complete:

Y

Release tags associated with all fabricated parts are attached:

Y

List all non-conformities raised: _____


Inspector Signature:31 Mar 14
Date:

CARGO BASKET HOOP FABRICATION - 90621

General

These instructions apply to cargo basket attachment hoop 90621-01-XX (-01 right, -02 left). Refer to the following drawings, at the current revision, for dimensions and details:

90621, Revision 0 – Attachment Hoop

84262, Revision 1 – Handle Bracket Assembly

Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

Work Order: 2014-36

Complete
(initial or SCA #)

Date Open: 25 MAR 2014

1. ½ Hoop Fabrication – ½" hoop APOL
 - a. Cut ½" x 0.035 material to 21.0", square ends.
 - b. Record material PO on attached material list.
 - c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
 - d. Remove writing on tubes with acetone and scotch bright.
 - e. On the hoop bending fixture, set the following stops:
 - i. Upper tube stop: ??"
 - ii. Lower bend stop: 12mm
 - f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
 - g. Slide shim all the way forward on bender to secure tube in die
 - h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
 - i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
 - j. Check for:
 - i. hoop height: 15.5" (Outside to outside)
 - ii. adjust upper stop for height if required
2. ½ Hoop Machining – ½" hoop – 84262-01 APOL
 - a. Start with ½" half hoop from step 1.
 - b. Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
 - c. Drill 2 places, 5/16" (0.313) holes using 5/16" (#4) centre drill through both sides in accordance with drawing. Run at 500 RPM. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
 - i. locate 0.23" from edge (within tolerance specified on drawing).
 - d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
 - e. Tag in process hoop(s) and place into stock.

AD04

3. ½ Hoop Fabrication – 1" hoop

- a. Cut 1" x 0.065 material to 32.0", both end square.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
 - i. Upper tube stop: ??"
 - ii. Lower bend stop: ??
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Using a long snipe tube, pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for angle using hoop jig. Adjust stops if required.
- j. Check for:
 - i. hoop height 16"
 - ii. adjust upper stop for height if required
 - iii. length to allow 60 degree cut.
- k. Using hoop jig, mark for 60 degree cut on bottom end. Cut to length.
- l. De-burr cut end using a sanding disc on a die-grinder or disc sander.

4. ½ Hoop Machining – 1" hoop

AD06

- a. Start with 1" ½ hoop as stock.
- b. Setup manual milling machine with standard steel vise jaws. Insert hoop into vise flat on bottom of vise. Set X 0 on edge of hoop (end of hoop). Shift X along hoop 0.75" and set X 0. Set stop against end of tube. Rotate milling head 5 degrees in or out as required for right or left side.
- c. Drill two places, 5/8" (0.625) holes using 5/8" (#7) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling. Ensure edge of hole to edge of tube is 0.23" as indicated on drawing.
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- e. Set tube in vise with 60 degree end on right.
- f. Using ½" coated carbide end mill, mill slot 2.25" deep (edge to edge, 2.0 edge to centre). Apply a bead of Rapid-Tap cutting oil along cut line before milling.
- g. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- h. Tag in process hoop(s) and place into stock.

5. Joint Preparation

AD06

- a. Set 1" hoop in hoop jig. Insert ½" hoop into 1" hoop, against side stop of jig. Mark slot location in 1" hoop onto ½" hoop. Trim ½" hoop with vertical bandsaw if required, and shape to match slot with disc sander.

6. Welding – Lugs

AD-05

- a. Insert two 90621-05 lugs into holes in 1" hoop. Set short side to 0.06" above surface of tube. Attach 11" spacing jig with 3/8-24 bolts to lugs.
- b. TIG weld all around outside of lugs. 2 places.

- c. Grind lugs flush with inside of tube.
- d. TIG weld all around inside of lugs. 2 places.
- e. Record lug and welding rod PO/WO on attached material list.

7. Welding – Handle Bushings – 84262-01

AD-05

- a. Insert 84271-01 bushings into ½" hoop prepared in step 2. above.
- b. TIG weld bushing both sides, 2 bushings per hoop.
- c. Record bushing and welding rod PO/WO on attached material list.

8. Welding – Hoop Assembly

AD-05

- a. Insert 1" hoop from step 6 and ½" hoop from step 7 into hoop jig. Seat ½" hoop into slot in 1" hoop.
- b. Tack weld hoops together, minimum 4 places, to hold hoop together to complete welds out of jig.
- c. TIG weld around ½" hoop in slot.
- d. Cap ½" – 1" tube joint with 76423-04 cap. TIG weld around cap.
- e. Record cap and welding rod PO/WO on attached material list.

9. Finishing and Inspection

AD-06

- a. Run 3/8-24 tap through welded lugs.
- b. Grind inside surfaces flush at lugs and slot in 1" tube.
- c. Inspect hoop for conformity to drawing.
- d. Tag complete and inspected hoop(s) and place into stock.

Work Order: 2014-36

Material Tracking Sheet

2 of 2

Date Opened: 25 MAR 2014

Robinson R44

Hoops Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			90621-01-	Hoop - attachment (aft)	(-01 RH, -02 LH)	
Step 1				1/2 Hoop Fabrication - 1/2" hoop		
	. 1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	14004
Step 2				Machining	None	
Step 3				1/2 Hoop Fabrication - 1" hoop		
	. 1		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	14014
Step 4				Machining	None	
Step 5				Joint Preparation	None	
				Welding		
Step 6	. 2		90621-05	Lug	1018 Mild Steel, 5/8" Dia.	12056
Step 7	. 2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	13023
Step 8	. 1		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	9010 / 12131 12131 12131 12131
	. A/R		--	Welding Rod	ER70S-2	PO# 14005
Step 9				Finishing and Inspection	None	

CARGO BASKET HOOP FABRICATION - 84262

General

These instructions apply to all cargo basket hoops that require handle bracket provisions. Refer to the following drawings, at the current revision, for dimensions and details:

Handle Provisions – Common to all baskets
84262, Revision 1 – Handle Bracket Assembly

Work Order: 2014-36

Complete
(initial or SCA #)

Date Open: ~~2014~~ JC

1. Handle Bushings – Preparation – 84262-01

AD06

Required in locations where handle brackets will be installed.

- a. Start with stock hoop or half hoop as required for specific basket assembly.
- b. Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
- c. Drill 2 places, 5/16" (0.313) holes using 5/16 (#4) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
 - i. locate 0.23" from edge (within tolerance specified on drawing).
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- e. Tag in process hoop(s) and place into stock.

2. Handle Bushings – Welding – 84262-01

AD-05

- a. Insert 84271-01 bushings into hoop prepared in step 2. above.
- b. TIG weld bushing both sides, 2 bushings per hoop.
- c. Record bushing and welding rod PO/WO on attached material list.
- d. Tag in process hoop(s) and place into stock.

3. Handle Bushings – Finish – 84262-01

AD06

- a. De-burr welded bushings.
- b. Inspect hoop for conformity to drawing.
- c. Tag complete and inspected hoop(s) and place into stock.

CARGO BASKET HOOP FABRICATION - 49210

General

These instructions apply to cargo basket hoop 49210-02 and derivatives that use it as stock. Refer to the following drawings, at the current revision, for dimensions and details:

20

49210, Revision 1 – Basket Component - Hoop

Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

Work Order:

2014-36

Complete

(initial or SCA #)

Date Open:

25 Mar 14

1. Hoop Fabrication – 49210-02

ADPb

- a. Cut $\frac{1}{2}$ " x 0.035 material to 48.0", square ends.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
 - i. Upper tube stop: 19?"
 - ii. Lower bend stop: 12mm
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
- j. Repeat steps f.-i. for opposite end of tube.
- k. Check for:
 - i. hoop height: 15.5" (Outside to outside)
 - ii. hoop width just above bends: 22" (outside to outside)
 - iii. adjust upper stop for height if required
 - iv. adjust stock length for width if required
 - v. twist – due to pulling bending arm up or down through bend
- l. Drill #30 vent holes in bottom centre of hoop in fore/aft direction. De-burr with scotch-brite disc on die-grinder.
- m. Inspect hoops for conformity to drawing.
- n. Tag complete and inspected hoop(s) and place into stock.

CARGO BASKET HOOP FABRICATION - 90622

General

These instructions apply to cargo basket forward attachment hoop 90622-01. Refer to the following drawings, at the current revision, for dimensions and details:

49210, Revision 1 – Basket Component - Hoop
90622, Revision 0 – Forward Attachment Hoop

Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

Work Order: 2014-36

Complete
(initial or SCA #)

Date Open: 25 MAR 2014

1. Forward Attachment Hoop – Preparation – 90622-01-XX APC
 - a. Start with 49210-02 hoop as stock.
 - b. Setup manual milling machine with standard steel vise jaw. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 7.25" and set X 0. Rotate milling head 5 degrees in or out as required for right or left side.
 - c. Using 5/8" (0.625) end mill, mill into side of tube in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before milling.
 - d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
 - e. Cut hoop at 9.10" high, at 36.5 degrees as indicated on drawing 90611.
 - f. Align milling head to vertical or flag machine.
 - g. Tag in process hoop(s) and place into stock.
2. Forward Attachment Hoop – Welding – 90622-01-XX AD-05
 - a. Attach two 69823-02 lugs to 4.5" spacing jig using 3/8-24 bolt. Align lugs to slots in hoop prepared in step 1. above. Centre bolts on hoop.
 - b. TIG weld lugs into hoop. Weld all around both lugs.
 - c. Record lug and welding rod PO/WO on attached material list.
 - d. Tag in process hoop(s) and place into stock.
3. Forward Attachment Hoop – Finish – 90622-01-XX APC
 - a. Run 3/8-24 tap through welded lugs.
 - b. Inspect hoop for conformity to drawing.
 - c. Tag complete and inspected hoop(s) and place into stock.

Work Order: 2014-36

Material Tracking Sheet

1 of 2

Date Opened: 25 MAR 2014Robinson R44
Hoops Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/NO
Step 1			49210-02	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	14009
Step 1			49210-02	Hoop - with handle provisions	4130 Steel, 1/2" x 0.035 Sqr. Tube	14009
Step 2				Welding		
	. 2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	
	. A/R		--	Welding Rod	ER70S-2	PO# 14005
Step 3				Inspection	None	
Step 1			90622-01-	Hoop - attachment	(-01 RH, -02 LH)	
	. 1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	14009
Step 2				Welding		
	. 2		69823-02	Lug	1018 Steel, 5/8" Rod	12056
	. A/R		--	Welding Rod	ER70S-2	PO# 14005
Step 3				Finishing and Inspection	None	

Date Opened: 25 March 2014

Job #: 906

Type / Project: Robinson R44 Standard Cargo Basket Mounting Hoops

Batch Quantity: 5

Approval: SH10-48

Drawing List: DCL906-12, Rev. 0

Drawing	Description	Task Sheet		Material List	
		Provided	Complete	Provided	Complete
90621, Rev. 0	Aft Attachment Hoop	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
- 84262, Rev. 1	Basket Handle Provisions				
90622, Rev. 0	Forward Attachment Hoop	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
49210, Rev. 1	Hoop	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
- 84262, Rev. 1	Basket Handle Provisions				

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:

Document Control List revision level matches (or exceeds) STC:

Drawings revision levels match Document Control List:

Y
Y
Y

Purchase order or Work order source is recorded for each part/ass'y:

Tests and inspections specifically called out on drawings are complete:

Release tags associated with all fabricated parts are attached:

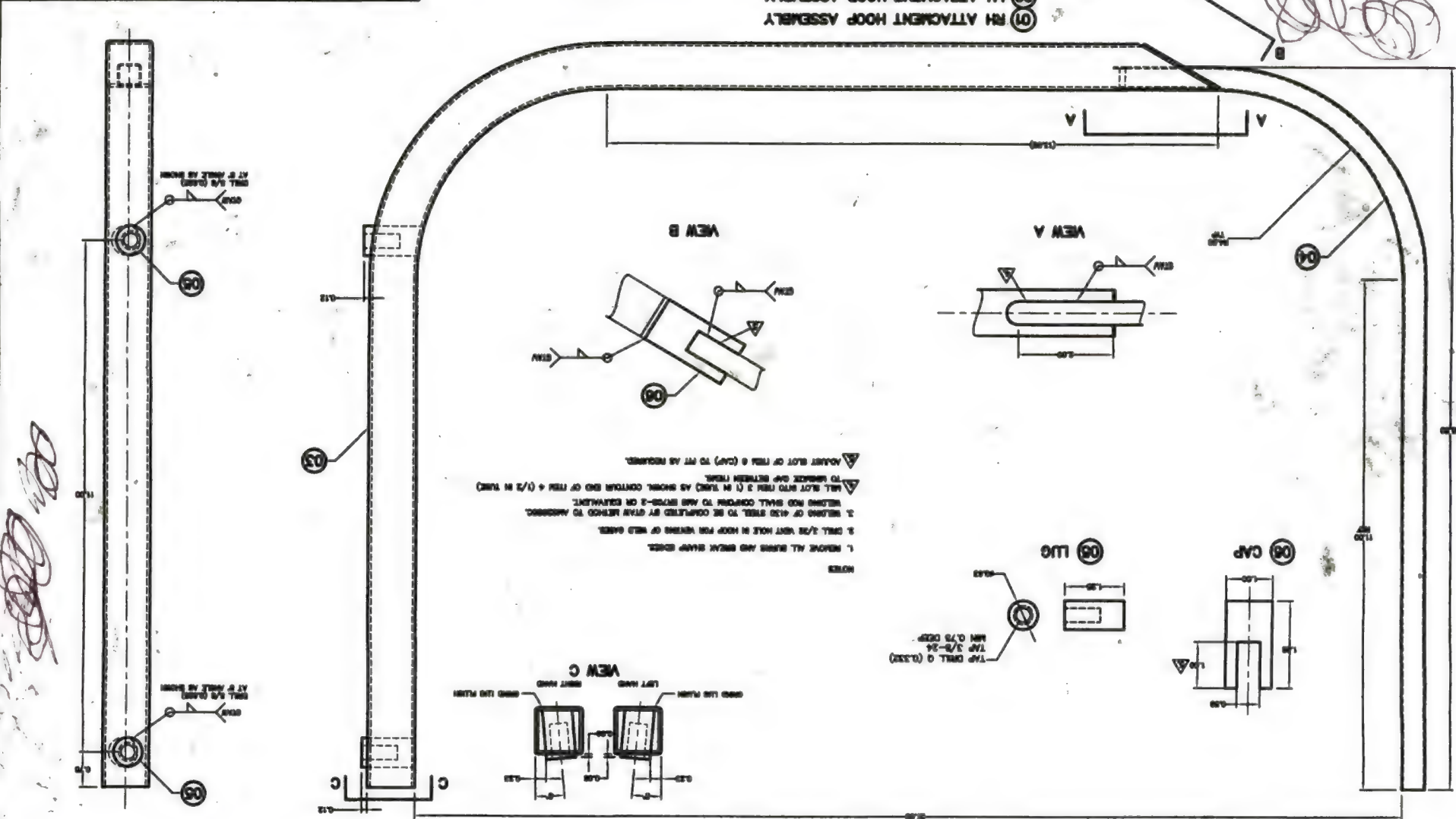
Y
Y
Y

List all non-conformities raised: _____


Inspector Signature:

31 Mar 14
Date:

REV. NO.	REV. DATE	REV. DESCRIPTION
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100	100/01/00	100

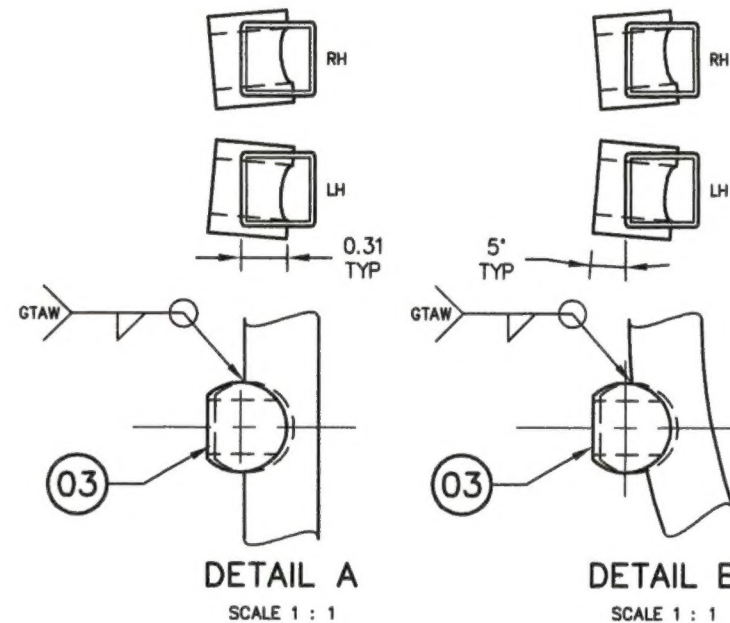
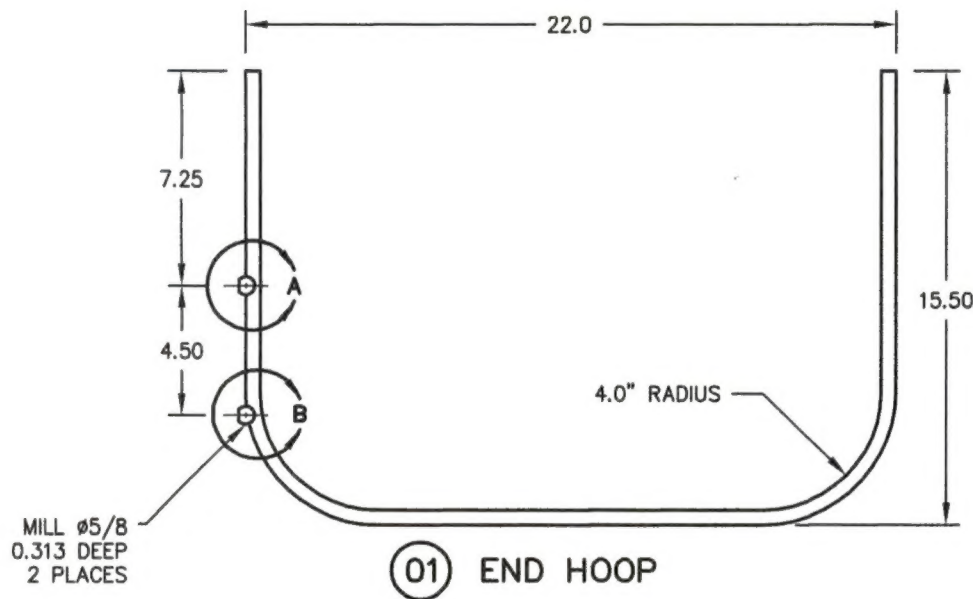
2014-36

Tilt
Head 5° forward Cutter Closer to you

Set 1" Hoop ~~with~~ facing up and ~~Right~~ Bottom of Hoop to the Right

#7 Center Drill
~~##~~

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. DRILL 3/32 VENT HOLE IN BOTTOM OF HOOP FOR VENTING OF WELD GASES
3. WELDING OF STEEL LUGS TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.

2	69823-02	03	LUG	1018 MILD STEEL	ISI 1010/1020	5/8 DIA ROD
	90622-01-02	01	LH FWD ATTACHMENT HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE
	90622-01-01	01	RH FWD ATTACHMENT HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

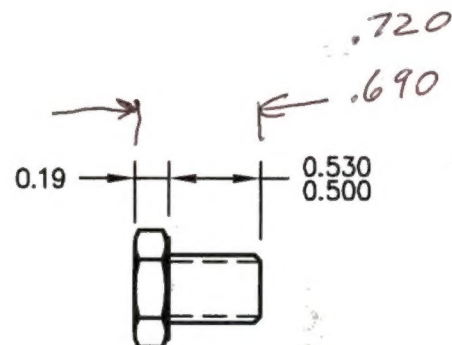
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.	APPROVALS		DATE		AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net			
	DRAWN: JEFF CLARKE		10 APR 2006					
	CHECKED: E. BURGON							
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				ROBINSON R44, R44 II QUICK RELEASE CARGO BASKET FORWARD ATTACHMENT HOOP FABRICATION			
DECIMALS		ANGLES		SCALE 1 : 5		DWG. SIZE	DWG. NO.	REV.
X.XXX ±0.010		±1/2°		SHEET 1 OF 1		LGL	90622	0
X.XX ±0.03								
X.X ±0.1								

WO 2014-36

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED	BJC	21/05/2014

NOTES


1. REMOVE ALL BURRS AND BREAK SHARP EDGES.



01 FITTING

90628-01	01	FITTING	GR18.8 STAINLESS STEEL	COMMERCIAL	3/8-24 X 0.75 BOLT
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

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	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1			<p>ROBINSON R44, R44 II QUICK RELEASE CARGO BASKET FITTING</p>		
	SCALE 1 : 1			DWG. SIZE A1	DWG. NO. 90628	REV. 1
	SHEET 1 OF 1					



WO# 2014-36

Approved Manufacturing Facility 73-04 Form 20.F.06 Rev. Original 27 May 2013